

## Message Text

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ORIGIN EB-07

INFO OCT-01 CIAE-00 COME-00 DODE-00 NRC-05 NSAE-00 TRSE-00

EUR-12 ERDA-05 ISO-00 ACDA-05 EA-07 /042 R

DRAFTED BY EB/ITP/EWT:RWPRACHT:ERS

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FM SECSTATE WASHDC

TO AMEMBASSY BERN

C O N F I D E N T I A L STATE 038287

EXCON

E.O. 11652: XGDS-1

TAGS: ESTC, COCOM, SZ, UR

SUBJECT: SWISS SALES OF N/C MACHINE TOOLS TO USSR

REF: BERN 687

FOLLOWING IS TEXT OF SUB-ITEM (B) OF IL 1091:

"(B) MACHINE TOOLS AND DIMENSIONAL INSPECTION MACHINES,  
WHICH ACCORDING TO THE MANUFACTURER'S TECHNICAL SPECIFI-  
CATIONS CAN BE EQUIPPED WITH CONTROLS COVERED BY SUB-ITEM  
(A) ABOVE EXCEPT:

(I) BORING MILLS, MILLING MACHINES, AND MACHINING CENTRES  
HAVING ALL OF THE FOLLOWING CHARACTERISTICS:

(1) MAXIMUM SLIDE TRAVEL IN ANY AXIS EQUAL TO OR LESS  
THAN 3,000 MM;

(2) POSITIONING ACCURACY OF ANY AXIS EQUAL TO OR GREATER  
THAN PLUS OR MINUS 0.01 MM PER 300 MM AND 0.005 MM FOR  
EACH ADDITIONAL 300 MM;

(3) SPINDLE POWER EQUAL TO OR LESS THAN 20 KW;

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(4) SINGLE WORKING SPINDLE; (SEE NOTE A)

(5) AXIAL AND RADIAL AXIS MOTION MEASURED AT THE SPINDLE AXIS IN ONE REVOLUTION OF THE SPINDLE EQUAL TO OR GREATER THAN  $D \times 2 \times 10^{-5}$  MM TIR (PEAK TO PEAK) WHERE D IS THE SPINDLE DIAMETER IN MILLIMETERS;  
(6) NOT MORE THAN 3 AXES (SEE NOTE B) CAPABLE OF SIMULTANEOUSLY COORDINATED CONTOURING MOTION REGARDLESS OF THE NC UNIT CONNECTED TO THE MACHINE.

(B)(II) MACHINE TOOLS, OTHER THAN THE MACHINES DESCRIBED IN (I) ABOVE, AND DIMENSIONAL INSPECTION MACHINES HAVING ALL THE FOLLOWING CHARACTERISTICS:

(1) POSITIONING ACCURACY OF ANY AXIS EQUAL TO OR GREATER THAN PLUS OR MINUS 0.01 MM PER 300 MM AND 0.005 MM FOR EACH ADDITIONAL 300 MM;  
(2) RADIAL AXIS MOTION MEASURED AT THE SPINDLE AXIS EQUAL TO OR GREATER THAN 0.0008 MM TIR (PEAK TO PEAK) IN ONE REVOLUTION OF THE SPINDLE (FOR LATHES AND OTHER TURNING MACHINES);  
(3) NOT MORE THAN 3 AXES (SEE NOTE B) CAPABLE OF SIMULTANEOUSLY COORDINATED CONTOURING MOTION REGARDLESS OF THE NC UNIT CONNECTED TO THE MACHINE.

NOTES:

A. MACHINES MAY HAVE MULTIPLE TOOL HEADS OR TURRETS, BUT ONLY ONE WORKING SPINDLE (STANDARD OR OPTIONAL) MAY BE OPERATIVE AT A TIME.  
B. MACHINES MAY HAVE MORE THAN ONE WORK STATION, BUT EACH STATION SHALL BE LIMITED TO 2-AXIS CONTOURING (E.G. VERTICAL TURRET LATHES WITH TWO INDEPENDENT RAILHEADS.) THE MACHINES MAY HAVE ONE OR MORE DISCRETE POSITIONING MODE AXES, (E.G. DISCRETE POSITIONING ROTARY TABLE) IN ADDITION TO THE THREE CONTOURING AXES. SECONDARY CONTOURING AXES PARALLEL TO PRIMARY CONTOURING AXES (E.G. W-AXIS OF A BORING MILL THAT HAS A PRIMARY Z-AXIS) ARE NOT TO BE CONSIDERED WHEN DETERMINING THE NUMBER OF CONTOURING AXES." INGERSOLL

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